

OM-303 155795N

January 2002

Description

Arc Welding Power Source



Gas Tungsten Arc (TIG) Welding



Shielded Metal Arc (Stick) Welding

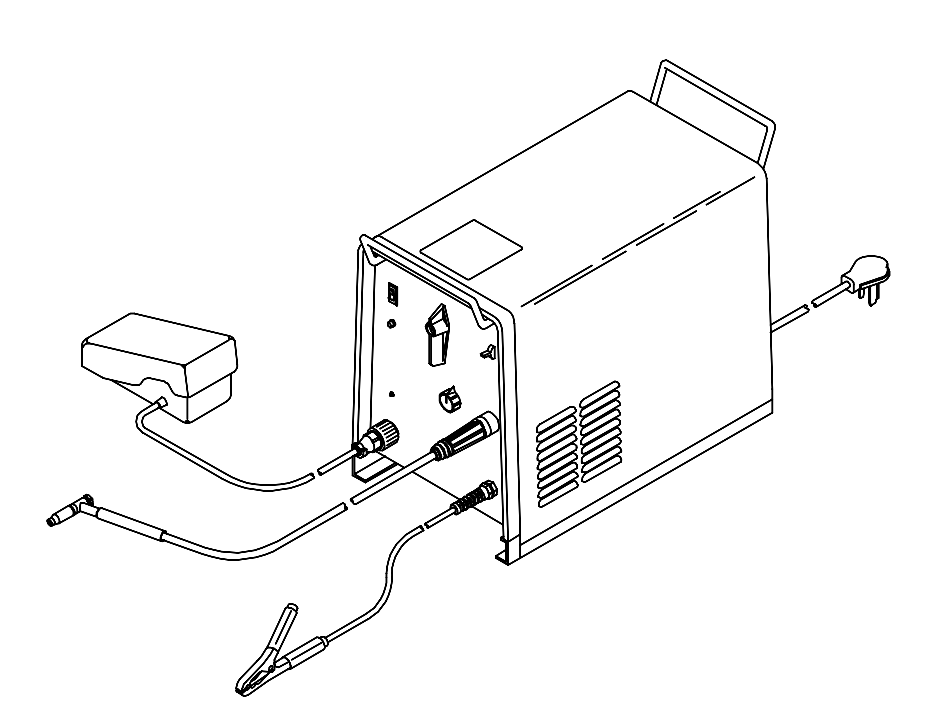
Processes







TIGMATE™



OWNER'S MANUAL

From Hobart to You

Thank you and *congratulations* on choosing Hobart. Now you can get the job done and get it done right. We know you don’t have time to do it any other way.

This Owner’s Manual is designed to help you get the most out of your Hobart products. Please take time to read the Safety precautions. They will help you protect yourself against potential hazards on the worksite. We’ve made installation and operation quick and easy. With Hobart you can count on years of reliable service with proper maintenance. And if for some reason the unit needs repair, there’s a Troubleshooting section that will help you figure out what the problem is. The parts list will then help you to decide the exact part you may need to fix the problem. Warranty and service information for your particular model are also provided.



Hobart is registered to the ISO 9001 Quality System Standard.

Hobart Welders manufactures a full line of welders and welding related equipment.
For information on other quality Hobart products, contact your local Hobart distributor to receive the latest full line catalog or individual catalog sheets.
To locate your nearest distributor or service agency call 1-877-Hobart1.



Working as hard as you do – every power source from Hobart is backed by the best warranty in the business.

Hobart offers a Technical Manual which provides more detailed service and parts information for your unit. To obtain a Technical Manual, contact your local distributor. Your distributor can also supply you with Welding Process Manuals such as SMAW, GTAW, GMAW, and GMAW-P.



TABLE OF CONTENTS

WARNING

This product, when used for welding or cutting, produces fumes or gases which contain chemicals known to the State of California to cause birth defects and, in some cases, cancer. (California Health & Safety Code Section 25249.5 et seq.)

The following terms are used interchangeably throughout this manual:
TIG = GTAW
Stick = SMAW

SECTION 1 – SAFETY PRECAUTIONS - READ BEFORE USING

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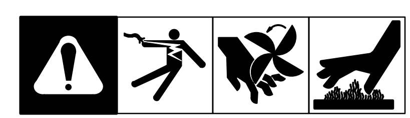
1-1. Symbol Usage



Means Warning! Watch Out! There are possible hazards with this procedure! The possible hazards are shown in the adjoining symbols.

▲ **Marks a special safety message.**

☞ *Means "Note"; not safety related.*



This group of symbols means Warning! Watch Out! possible ELECTRIC SHOCK, MOVING PARTS, and HOT PARTS hazards. Consult symbols and related instructions below for necessary actions to avoid the hazards.

1-2. Arc Welding Hazards

▲ **The symbols shown below are used throughout this manual to call attention to and identify possible hazards. When you see the symbol, watch out, and follow the related instructions to avoid the hazard. The safety information given below is only a summary of the more complete safety information found in the Safety Standards listed in Section 1-4. Read and follow all Safety Standards.**

▲ **Only qualified persons should install, operate, maintain, and repair this unit.**

▲ **During operation, keep everybody, especially children, away.**

ELECTRIC SHOCK can kill.

Touching live electrical parts can cause fatal shocks or severe burns. The electrode and work circuit is electrically live whenever the output is on. The input power circuit and machine internal circuits are also live when power is on. In semiautomatic or automatic wire welding, the wire, wire reel, drive roll housing, and all metal parts touching the welding wire are electrically live. Incorrectly installed or improperly grounded equipment is a hazard.

- Do not touch live electrical parts.
- Wear dry, hole-free insulating gloves and body protection.
- Insulate yourself from work and ground using dry insulating mats or covers big enough to prevent any physical contact with the work or ground.
- Do not use AC output in damp areas, if movement is confined, or if there is a danger of falling.
- Use AC output ONLY if required for the welding process.
- If AC output is required, use remote output control if present on unit.
- Disconnect input power or stop engine before installing or servicing this equipment. Lockout/tagout input power according to OSHA 29 CFR 1910.147 (see Safety Standards).
- Properly install and ground this equipment according to its Owner's Manual and national, state, and local codes.
- Always verify the supply ground – check and be sure that input power cord ground wire is properly connected to ground terminal in disconnect box or that cord plug is connected to a properly grounded receptacle outlet.
- When making input connections, attach proper grounding conductor first – double-check connections.
- Frequently inspect input power cord for damage or bare wiring – replace cord immediately if damaged – bare wiring can kill.
- Turn off all equipment when not in use.
- Do not use worn, damaged, undersized, or poorly spliced cables.
- Do not drape cables over your body.
- If earth grounding of the workpiece is required, ground it directly with a separate cable.
- Do not touch electrode if you are in contact with the work, ground, or another electrode from a different machine.
- Use only well-maintained equipment. Repair or replace damaged parts at once. Maintain unit according to manual.
- Wear a safety harness if working above floor level.
- Keep all panels and covers securely in place.
- Clamp work cable with good metal-to-metal contact to workpiece or worktable as near the weld as practical.
- Insulate work clamp when not connected to workpiece to prevent contact with any metal object.
- Do not connect more than one electrode or work cable to any single weld output terminal.

SIGNIFICANT DC VOLTAGE exists after removal of input power on inverters.

- Turn Off inverter, disconnect input power, and discharge input capacitors according to instructions in Maintenance Section before touching any parts.



FUMES AND GASES can be hazardous.

Welding produces fumes and gases. Breathing these fumes and gases can be hazardous to your health.

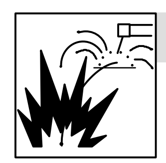
- Keep your head out of the fumes. Do not breathe the fumes.
- If inside, ventilate the area and/or use exhaust at the arc to remove welding fumes and gases.
- If ventilation is poor, use an approved air-supplied respirator.
- Read the Material Safety Data Sheets (MSDSs) and the manufacturer's instructions for metals, consumables, coatings, cleaners, and degreasers.
- Work in a confined space only if it is well ventilated, or while wearing an air-supplied respirator. Always have a trained watch-person nearby. Welding fumes and gases can displace air and lower the oxygen level causing injury or death. Be sure the breathing air is safe.
- Do not weld in locations near degreasing, cleaning, or spraying operations. The heat and rays of the arc can react with vapors to form highly toxic and irritating gases.
- Do not weld on coated metals, such as galvanized, lead, or cadmium plated steel, unless the coating is removed from the weld area, the area is well ventilated, and if necessary, while wearing an air-supplied respirator. The coatings and any metals containing these elements can give off toxic fumes if welded.



ARC RAYS can burn eyes and skin.

Arc rays from the welding process produce intense visible and invisible (ultraviolet and infrared) rays that can burn eyes and skin. Sparks fly off from the weld.

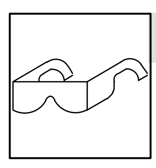
- Wear a welding helmet fitted with a proper shade of filter to protect your face and eyes when welding or watching (see ANSI Z49.1 and Z87.1 listed in Safety Standards).
- Wear approved safety glasses with side shields under your helmet.
- Use protective screens or barriers to protect others from flash and glare; warn others not to watch the arc.
- Wear protective clothing made from durable, flame-resistant material (leather and wool) and foot protection.



WELDING can cause fire or explosion.

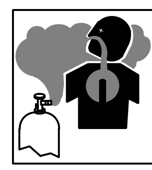
Welding on closed containers, such as tanks, drums, or pipes, can cause them to blow up. Sparks can fly off from the welding arc. The flying sparks, hot workpiece, and hot equipment can cause fires and burns. Accidental contact of electrode to metal objects can cause sparks, explosion, overheating, or fire. Check and be sure the area is safe before doing any welding.

- Protect yourself and others from flying sparks and hot metal.
- Do not weld where flying sparks can strike flammable material.
- Remove all flammables within 35 ft (10.7 m) of the welding arc. If this is not possible, tightly cover them with approved covers.
- Be alert that welding sparks and hot materials from welding can easily go through small cracks and openings to adjacent areas.
- Watch for fire, and keep a fire extinguisher nearby.
- Be aware that welding on a ceiling, floor, bulkhead, or partition can cause fire on the hidden side.
- Do not weld on closed containers such as tanks, drums, or pipes, unless they are properly prepared according to AWS F4.1 (see Safety Standards).
- Connect work cable to the work as close to the welding area as practical to prevent welding current from traveling long, possibly unknown paths and causing electric shock and fire hazards.
- Do not use welder to thaw frozen pipes.
- Remove stick electrode from holder or cut off welding wire at contact tip when not in use.
- Wear oil-free protective garments such as leather gloves, heavy shirt, cuffless trousers, high shoes, and a cap.
- Remove any combustibles, such as a butane lighter or matches, from your person before doing any welding.



FLYING METAL can injure eyes.

- Welding, chipping, wire brushing, and grinding cause sparks and flying metal. As welds cool, they can throw off slag.
- Wear approved safety glasses with side shields even under your welding helmet.



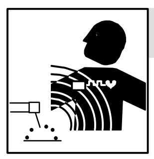
BUILDUP OF GAS can injure or kill.

- Shut off shielding gas supply when not in use.
- Always ventilate confined spaces or use approved air-supplied respirator.



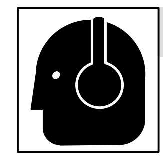
HOT PARTS can cause severe burns.

- Do not touch hot parts bare handed.
- Allow cooling period before working on gun or torch.



MAGNETIC FIELDS can affect pacemakers.

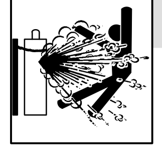
- Pacemaker wearers keep away.
- Wearers should consult their doctor before going near arc welding, gouging, or spot welding operations.



NOISE can damage hearing.

Noise from some processes or equipment can damage hearing.

- Wear approved ear protection if noise level is high.

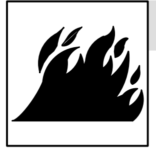


CYLINDERS can explode if damaged.

Shielding gas cylinders contain gas under high pressure. If damaged, a cylinder can explode. Since gas cylinders are normally part of the welding process, be sure to treat them carefully.

- Protect compressed gas cylinders from excessive heat, mechanical shocks, slag, open flames, sparks, and arcs.
- Install cylinders in an upright position by securing to a stationary support or cylinder rack to prevent falling or tipping.
- Keep cylinders away from any welding or other electrical circuits.
- Never drape a welding torch over a gas cylinder.
- Never allow a welding electrode to touch any cylinder.
- Never weld on a pressurized cylinder – explosion will result.
- Use only correct shielding gas cylinders, regulators, hoses, and fittings designed for the specific application; maintain them and associated parts in good condition.
- Turn face away from valve outlet when opening cylinder valve.
- Keep protective cap in place over valve except when cylinder is in use or connected for use.
- Read and follow instructions on compressed gas cylinders, associated equipment, and CGA publication P-1 listed in Safety Standards.

1-3. Additional Symbols For Installation, Operation, And Maintenance



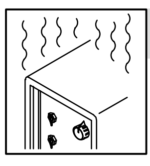
FIRE OR EXPLOSION hazard.

- Do not install or place unit on, over, or near combustible surfaces.
- Do not install unit near flammables.
- Do not overload building wiring – be sure power supply system is properly sized, rated, and protected to handle this unit.



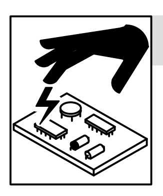
FALLING UNIT can cause injury.

- Use lifting eye to lift unit only, NOT running gear, gas cylinders, or any other accessories.
- Use equipment of adequate capacity to lift and support unit.
- If using lift forks to move unit, be sure forks are long enough to extend beyond opposite side of unit.



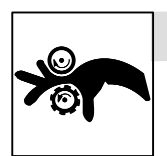
OVERUSE can cause OVERHEATING

- Allow cooling period; follow rated duty cycle.
- Reduce current or reduce duty cycle before starting to weld again.
- Do not block or filter airflow to unit.



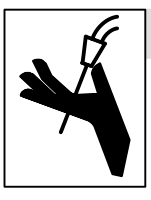
STATIC (ESD) can damage PC boards.

- Put on grounded wrist strap BEFORE handling boards or parts.
- Use proper static-proof bags and boxes to store, move, or ship PC boards.



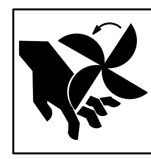
MOVING PARTS can cause injury.

- Keep away from moving parts.
- Keep away from pinch points such as drive rolls.



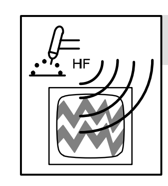
WELDING WIRE can cause injury.

- Do not press gun trigger until instructed to do so.
- Do not point gun toward any part of the body, other people, or any metal when threading welding wire.



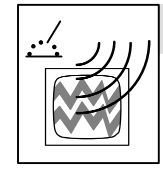
MOVING PARTS can cause injury.

- Keep away from moving parts such as fans.
- Keep all doors, panels, covers, and guards closed and securely in place.



H.F. RADIATION can cause interference.

- High-frequency (H.F.) can interfere with radio navigation, safety services, computers, and communications equipment.
- Have only qualified persons familiar with electronic equipment perform this installation.
- The user is responsible for having a qualified electrician promptly correct any interference problem resulting from the installation.
- If notified by the FCC about interference, stop using the equipment at once.
- Have the installation regularly checked and maintained.
- Keep high-frequency source doors and panels tightly shut, keep spark gaps at correct setting, and use grounding and shielding to minimize the possibility of interference.



ARC WELDING can cause interference.

- Electromagnetic energy can interfere with sensitive electronic equipment such as computers and computer-driven equipment such as robots.
- Be sure all equipment in the welding area is electromagnetically compatible.
- To reduce possible interference, keep weld cables as short as possible, close together, and down low, such as on the floor.
- Locate welding operation 100 meters from any sensitive electronic equipment.
- Be sure this welding machine is installed and grounded according to this manual.
- If interference still occurs, the user must take extra measures such as moving the welding machine, using shielded cables, using line filters, or shielding the work area.

1-4. Principal Safety Standards

Safety in Welding and Cutting, ANSI Standard Z49.1, from American Welding Society, 550 N.W. LeJeune Rd, Miami FL 33126

Safety and Health Standards, OSHA 29 CFR 1910, from Superintendent of Documents, U.S. Government Printing Office, Washington, D.C. 20402.

Recommended Safe Practices for the Preparation for Welding and Cutting of Containers That Have Held Hazardous Substances, American Welding Society Standard AWS F4.1, from American Welding Society, 550 N.W. LeJeune Rd, Miami, FL 33126

National Electrical Code, NFPA Standard 70, from National Fire Protection Association, Batterymarch Park, Quincy, MA 02269.

Safe Handling of Compressed Gases in Cylinders, CGA Pamphlet P-1, from Compressed Gas Association, 1235 Jefferson Davis Highway, Suite 501, Arlington, VA 22202.

Code for Safety in Welding and Cutting, CSA Standard W117.2, from Canadian Standards Association, Standards Sales, 178 Rexdale Boulevard, Rexdale, Ontario, Canada M9W 1R3.

Safe Practices For Occupation And Educational Eye And Face Protection, ANSI Standard Z87.1, from American National Standards Institute, 1430 Broadway, New York, NY 10018.

Cutting And Welding Processes, NFPA Standard 51B, from National Fire Protection Association, Batterymarch Park, Quincy, MA 02269.

1-5. EMF Information

Considerations About Welding And The Effects Of Low Frequency Electric And Magnetic Fields

Welding current, as it flows through welding cables, will cause electromagnetic fields. There has been and still is some concern about such fields. However, after examining more than 500 studies spanning 17 years of research, a special blue ribbon committee of the National Research Council concluded that: “The body of evidence, in the committee's judgment, has not demonstrated that exposure to power-frequency electric and magnetic fields is a human-health hazard.” However, studies are still going forth and evidence continues to be examined. Until the final conclusions of the research are reached, you may wish to minimize your exposure to electromagnetic fields when welding or cutting.

To reduce magnetic fields in the workplace, use the following procedures:

1. Keep cables close together by twisting or taping them.
2. Arrange cables to one side and away from the operator.
3. Do not coil or drape cables around your body.
4. Keep welding power source and cables as far away from operator as practical.
5. Connect work clamp to workpiece as close to the weld as possible.

About Pacemakers:

Pacemaker wearers consult your doctor first. If cleared by your doctor, then following the above procedures is recommended.

SECTION 1 – CONSIGNES DE SECURITE – LIRE AVANT UTILISATION

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1-1. Signification des symboles



Signifie Mise en garde ! Soyez vigilant ! Cette procédure présente des risques de danger ! Ceux-ci sont identifiés par des symboles adjacents aux directives.

▲ **Identifie un message de sécurité particulier.**

☞ *Signifie NOTA ; n'est pas relatif à la sécurité.*

Ce groupe de symboles signifie Mise en garde ! Soyez vigilant ! Il y a des risques de danger reliés aux CHOCS ÉLECTRIQUES, aux PIÈCES EN MOUVEMENT et aux PIÈCES CHAUDES. Reportez-vous aux symboles et aux directives ci-dessous afin de connaître les mesures à prendre pour éviter tout danger.

1-2. Dangers relatifs au soudage à l'arc

▲ **Les symboles présentés ci-après sont utilisés tout au long du présent manuel pour attirer votre attention et identifier les risques de danger. Lorsque vous voyez un symbole, soyez vigilant et suivez les directives mentionnées afin d'éviter tout danger. Les consignes de sécurité présentées ci-après ne font que résumer l'information contenue dans les normes de sécurité énumérées à la section 1-4. Veuillez lire et respecter toutes ces normes de sécurité.**

▲ **L'installation, l'utilisation, l'entretien et les réparations ne doivent être confiés qu'à des personnes qualifiées.**

▲ **Au cours de l'utilisation, tenir toute personne à l'écart et plus particulièrement les enfants.**



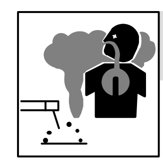
UN CHOC ÉLECTRIQUE peut tuer.

Un simple contact avec des pièces électriques peut provoquer une électrocution ou des blessures graves. L'électrode et le circuit de soudage sont sous tension dès que l'appareil est sur ON. Le circuit d'entrée et les circuits internes de l'appareil sont également sous tension à ce moment-là. En soudage semi-automatique ou automatique, le fil, le dévidoir, le logement des galets d'entraînement et les pièces métalliques en contact avec le fil de soudage sont sous tension. Des matériels mal installés ou mal mis à la terre présentent un danger.

- Ne jamais toucher les pièces électriques sous tension.
- Porter des gants et des vêtements de protection secs ne comportant pas de trous.
- S'isoler de la pièce et de la terre au moyen de tapis ou d'autres moyens isolants suffisamment grands pour empêcher le contact physique éventuel avec la pièce ou la terre.
- Ne pas se servir de source électrique àcourant électrique dans les zones humides, dans les endroits confinés ou là où on risque de tomber.
- Se servir d'une source électrique àcourant électrique UNIQUEMENT si le procédé de soudage le demande.
- Si l'utilisation d'une source électrique àcourant électrique s'avère nécessaire, se servir de la fonction de télécommande si l'appareil en est équipé.
- Couper l'alimentation ou arrêter le moteur avant de procéder à l'installation, à la réparation ou à l'entretien de l'appareil. Déverrouiller l'alimentation selon la norme OSHA 29 CFR 1910.147 (voir normes de sécurité).
- Installer et mettre à la terre correctement cet appareil conformément à son manuel d'utilisation et aux codes nationaux, provinciaux et municipaux.
- Toujours vérifier la terre du cordon d'alimentation – Vérifier et s'assurer que le fil de terre du cordon d'alimentation est bien raccordé à la borne de terre du sectionneur ou que la fiche du cordon est raccordée à une prise correctement mise à la terre.
- En effectuant les raccordements d'entrée fixer d'abord le conducteur de mise à la terre approprié et contre-vérifier les connexions.
- Vérifier fréquemment le cordon d'alimentation pour voir s'il n'est pas endommagé ou dénudé – remplacer le cordon immédiatement s'il est endommagé – un câble dénudé peut provoquer une électrocution.
- Mettre l'appareil hors tension quand on ne l'utilise pas.
- Ne pas utiliser des câbles usés, endommagés, de grosseur insuffisante ou mal épissés.
- Ne pas enrouler les câbles autour du corps.
- Si la pièce soudée doit être mise à la terre, le faire directement avec un câble distinct.
- Ne pas toucher l'électrode quand on est en contact avec la pièce, la terre ou une électrode provenant d'une autre machine.
- N'utiliser qu'un matériel en bon état. Réparer ou remplacer sur-le-champ les pièces endommagées. Entretenir l'appareil conformément à ce manuel.
- Porter un harnais de sécurité quand on travaille en hauteur.
- Maintenir solidement en place tous les panneaux et capots.
- Fixer le câble de retour de façon à obtenir un bon contact métal-métal avec la pièce à souder ou la table de travail, le plus près possible de la soudure.
- Isoler la pince de masse quand pas mis à la pièce pour éviter le contact avec tout objet métallique.

Il y a DU COURANT CONTINU IMPORTANT dans les convertisseurs après la suppression de l'alimentation électrique.

- Arrêter les convertisseurs, débrancher le courant électrique, et décharger les condensateurs d'alimentation selon les instructions indiquées dans la partie entretien avant de toucher les pièces.



LES FUMÉES ET LES GAZ peuvent être dangereux.

Le soudage génère des fumées et des gaz. Leur inhalation peut être dangereux pour votre santé.

- Eloigner votre tête des fumées. Ne pas respirer les fumées.
- A l'intérieur, ventiler la zone et/ou utiliser un échappement au niveau de l'arc pour l'évacuation des fumées et des gaz de soudage.
- Si la ventilation est insuffisante, utiliser un respirateur à alimentation d'air homologué.
- Lire les spécifications de sécurité des matériaux (MSDSs) et les instructions du fabricant concernant les métaux, les consommables, les revêtements, les nettoyants et les dégraisseurs.
- Travailler dans un espace fermé seulement s'il est bien ventilé ou en portant un respirateur à alimentation d'air. Demander toujours à un surveillant dûment formé de se tenir à proximité. Des fumées et des gaz de soudage peuvent déplacer l'air et abaisser le niveau d'oxygène provoquant des blessures ou des accidents mortels. S'assurer que l'air de respiration ne présente aucun danger.
- Ne pas souder dans des endroits situés à proximité d'opérations de dégraissage, de nettoyage ou de pulvérisation. La chaleur et les rayons de l'arc peuvent réagir en présence de vapeurs et former des gaz hautement toxiques et irritants.
- Ne pas souder des métaux munis d'un revêtement, tels que l'acier galvanisé, plaqué en plomb ou au cadmium à moins que le revêtement n'ait été enlevé dans la zone de soudure, que l'endroit soit bien ventilé, et si nécessaire, en portant un respirateur à alimentation d'air. Les revêtements et tous les métaux renfermant ces éléments peuvent dégager des fumées toxiques en cas de soudage.



LES RAYONS DE L'ARC peuvent provoquer des brûlures dans les yeux et sur la peau.

Le rayonnement de l'arc du procédé de soudage génère des rayons visibles et invisibles intenses (ultraviolets et infrarouges) susceptibles de provoquer des brûlures dans les yeux et sur la peau. Des étincelles sont projetées pendant le soudage.

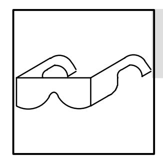
- Porter un casque de soudage muni d'un écran de filtre approprié pour protéger votre visage et vos yeux pendant le soudage ou pour regarder (voir ANSI Z49.1 et Z87.1 énuméré dans les normes de sécurité).
- Porter des protections approuvés pour les oreilles si le niveau sondre est trop élevé.
- Utiliser des écrans ou des barrières pour protéger des tiers de l'éclair et de l'éblouissement; demander aux autres personnes de ne pas regarder l'arc.
- Porter des vêtements de protection constitué dans une matière durable, résistant au feu (cuir ou laine) et une protection des pieds.



LE SOUDAGE peut provoquer un incendie ou une explosion.

Le soudage effectué sur des conteneurs fermés tels que des réservoirs, tambours ou des conduites peut provoquer leur éclatement. Des étincelles peuvent être projetées de l'arc de soudure. La projection d'étincelles, des pièces chaudes et des équipements chauds peut provoquer des incendies et des brûlures. Le contact accidentel de l'électrode avec des objets métalliques peut provoquer des étincelles, une explosion, un surchauffement ou un incendie. Avant de commencer le soudage, vérifier et s'assurer que l'endroit ne présente pas de danger.

- Se protéger et d'autres personnes de la projection d'étincelles et de métal chaud.
- Ne pas souder dans un endroit là où des étincelles peuvent tomber sur des substances inflammables.
- Déplacer toutes les substances inflammables à une distance de 10,7 m de l'arc de soudage. En cas d'impossibilité les recouvrir soigneusement avec des protections homologués.
- Des étincelles et des matériaux chauds du soudage peuvent facilement passer dans d'autres zones en traversant de petites fissures et des ouvertures.
- Surveiller tout déclenchement d'incendie et tenir un extincteur à proximité.
- Le soudage effectué sur un plafond, plancher, paroi ou séparation peut déclencher un incendie de l'autre côté.
- Ne pas effectuer le soudage sur des conteneurs fermés tels que des réservoirs, tambours, ou conduites, à moins qu'ils n'aient été préparés correctement conformément à AWS F4.1 (voir les normes de sécurité).
- Brancher le câble sur la pièce le plus près possible de la zone de soudage pour éviter le transport du courant sur une longue distance par des chemins inconnus éventuels en provoquant des risques d'électrocution et d'incendie.
- Ne pas utiliser le poste de soudage pour dégeler des conduites gelées.
- En cas de non utilisation, enlever la baguette d'électrode du porte-électrode ou couper le fil à la pointe de contact.
- Porter des vêtements de protection dépourvus d'huile tels que des gants en cuir, une chemise en matériau lourd, des pantalons sans revers, des chaussures hautes et un couvre chef.
- Avant de souder, retirer toute substance combustible de vos poches telles qu'un allumeur au butane ou des allumettes.



DES PARTICULES VOLANTES peuvent blesser les yeux.

- Le soudage, l'écaillement, le passage de la pièce à la brosse en fil de fer, et le meulage génèrent des étincelles et des particules métalliques volantes. Pendant la période de refroidissement des soudures, elles risquent de projeter du laitier.
- Porter des lunettes de sécurité avec écrans latéraux ou un écran facial.



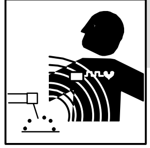
LES ACCUMULATIONS DE GAZ risquent de provoquer des blessures ou même la mort.

- Fermer l'alimentation du gaz protecteur en cas de non utilisation.
- Veiller toujours à bien aérer les espaces confinés ou se servir d'un respirateur d'adduction d'air homologué.



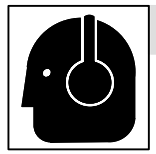
DES PIÈCES CHAUDES peuvent provoquer des brûlures graves.

- Ne pas toucher des parties chaudes à mains nues
- Prévoir une période de refroidissement avant d'utiliser le pistolet ou la torche.



LES CHAMPS MAGNÉTIQUES peuvent affecter les stimulateurs cardiaques.

- Porteurs de stimulateur cardiaque, restez à distance.
- Les porteurs d'un stimulateur cardiaque doivent d'abord consulter leur médecin avant de s'approcher des opérations de soudage à l'arc, de gougeage ou de soudage par points.



LE BRUIT peut affecter l'ouïe.

Le bruit des processus et des équipements peut affecter l'ouïe.

- Porter des protections approuvés pour les oreilles si le niveau sondre est trop élevé.

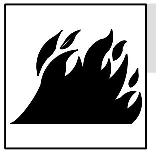


Si des BOUTEILLES sont endommagées, elles pourront exploser.

Des bouteilles de gaz protecteur contiennent du gaz sous haute pression. Si une bouteille est endommagée, elle peut exploser. Du fait que les bouteilles de gaz font normalement partie du procédé de soudage, les manipuler avec précaution.

- Protéger les bouteilles de gaz comprimé d'une chaleur excessive, des chocs mécaniques, du laitier, des flammes ouvertes, des étincelles et des arcs.
- Placer les bouteilles debout en les fixant dans un support stationnaire ou dans un porte-bouteilles pour les empêcher de tomber ou de se renverser.
- Tenir les bouteilles éloignées des circuits de soudage ou autres circuits électriques.
- Ne jamais placer une torche de soudage sur une bouteille à gaz.
- Une électrode de soudage ne doit jamais entrer en contact avec une bouteille.
- Ne jamais souder une bouteille pressurisée – risque d'explosion.
- Utiliser seulement des bouteilles de gaz protecteur, régulateurs, tuyaux et raccords convenables pour cette application spécifique; les maintenir ainsi que les éléments associés en bon état.
- Ne pas tenir la tête en face de la sortie en ouvrant la soupape de la bouteille.
- Maintenir le chapeau de protection sur la soupape, sauf en cas d'utilisation ou de branchement de la bouteille.
- Lire et suivre les instructions concernant les bouteilles de gaz comprimé, les équipements associés et les publications P-1 CGA énumérées dans les normes de sécurité.

1-3. Dangers supplémentaires en relation avec l'installation, le fonctionnement et la maintenance



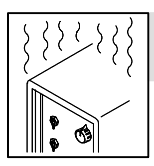
Risque D'INCENDIE OU D'EXPLOSION.

- Ne pas placer l'appareil sur, au-dessus ou à proximité de surfaces infllammables.
- Ne pas installer l'appareil à proximité de produits inflammables
- Ne pas surcharger l'installation électrique – s"assurer que l'alimentation est correctement dimensionné et protégé avant de mettre l'appareil en service.



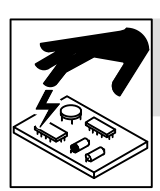
LA CHUTE DE L'APPAREIL peut blesser.

- Utiliser l'anneau de levage uniquement pour soulever l'appareil, NON PAS les chariot, les bouteilles de gaz ou toute autre accessoire.
- Utiliser un engin d'une capacité appropriée pour soulever l'appareil.
- En utilisant des fourches de levage pour déplacer l'unité, s'assurer que les fourches sont suffisamment longues pour dépasser du côté opposé de l'appareil.



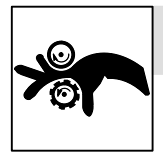
L'EMPLOI EXCESSIF peut SURCHAUFFER L'ÉQUIPEMENT.

- Prévoir une période de refroidissement, respecter le cycle opératoire nominal.
- Réduire le courant ou le cycle opératoire avant de recommancer le soudage.
- Ne pas obstruer les passages d'air du poste.



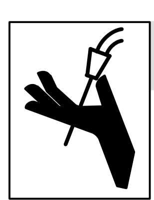
LES CHARGES ÉLECTROSTATIQUES peuvent endommager les circuits imprimés.

- Établir la connexion avec la barrette de terre avant de manipuler des cartes ou des pièces.
- Utiliser des pochettes et des boîtes antistatiques pour stocker, déplacer ou expédier des cartes de circuits imprimes.



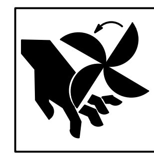
DES ORGANES MOBILES peuvent provoquer des blessures.

- Ne pas s'approcher des organes mobiles.
- Ne pas s'approcher des points de coincement tels que des rouleaux de commande.



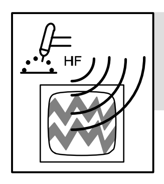
LES FILS DE SOUDAGE peuvent provoquer des blessures.

- Ne pas appuyer sur la gachette avant d'en avoir reçu l'instruction.
- Ne pas diriger le pistolet vers soi, d'autres personnes ou toute pièce mécanique en engageant le fil de soudage.



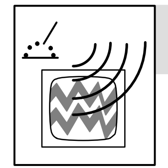
DES ORGANES MOBILES peuvent provoquer des blessures.

- Rester à l'écart des organes mobiles comme le ventilateur.
- Maintenir fermés et fixement en place les portes, panneaux, recouvrements et dispositifs de protection.



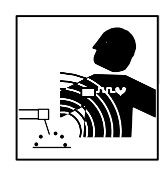
LE RAYONNEMENT HAUTE FRÉQUENCE (H.F.) risque de provoquer des interférences.

- Le rayonnement haute frequence peut provoquer des interférences avec les équipements de radio–navigation et de communication, les services de sécurité et les ordinateurs.
- Demander seulement à des personnes qualifiées familiarisées avec des équipements électroniques de faire fonctionner l'installation.
- L'utilisateur est tenu de faire corriger rapidement par un électricien qualifié les interférences résultant de l'installation.
- Si le FCC signale des interférences, arrêter immédiatement l'appareil.
- Effectuer régulièrement le contrôle et l'entretien de l'installation.
- Maintenir soigneusement fermés les portes et les panneaux des sources de haute fréquence, maintenir les éclateurs à une distance correcte et utiliser une terre et et un blindage pour réduire les interférences éventuelles.



LE SOUDAGE À L'ARC risque de provoquer des interférences.

- L'énergie électromagnétique risque de provoquer des interférences pour l'équipement électronique sensible tel que les ordinateurs et l'équipement commandé par ordinateur tel que les robots.
- Veiller à ce que tout l'équipement de la zone de soudage soit compatible électromagnétiquement.
- Pour réduire la possibilité d'interférence, maintenir les câbles de soudage aussi courts que possible, les grouper, et les poser aussi bas que possible (ex. par terre).
- Veiller à souder à une distance de 100 mètres de tout équipement électronique sensible.
- Veiller à ce que ce poste de soudage soit posé et mis à la terre conformément à ce mode d'emploi.
- En cas d'interférences après avoir pris les mesures précédentes, il incombe à l'utilisateur de prendre des mesures supplémentaires telles que le déplacement du poste, l'utilisation de câbles blindés, l'utilisation de filtres de ligne ou la pose de protecteurs dans la zone de travail.



LES CHAMPS MAGNÉTIQUES peuvent affecter les stimulateurs cardiaques.

- Porteurs de stimulateur cardiaque, restez à distance.
- Les porteurs d'un stimulateur cardiaque doivent d'abord consulter leur médecin avant de s'approcher des opérations de soudage à l'arc, de gougeage ou de soudage par points.

1-4. Principales normes de sécurité

Safety in Welding and Cutting, norme ANSI Z49.1, de l’American Welding Society, 550 N.W. Lejeune Rd, Miami FL 33126

Safety and Health Sandards, OSHA 29 CFR 1910, du Superintendent of Documents, U.S. Government Printing Office, Washington, D.C. 20402.

Recommended Safe Practice for the Preparation for Welding and Cutting of Containers That Have Held Hazardous Substances, norme AWS F4.1, de l’American Welding Society, 550 N.W. Lejeune Rd, Miami FL 33126

National Electrical Code, NFPA Standard 70, de la National Fire Protection Association, Batterymarch Park, Quincy, MA 02269.

Safe Handling of Compressed Gases in Cylinders, CGA Pamphlet P-1, de la Compressed Gas Association, 1235 Jefferson Davis Highway, Suite 501, Arlington, VA 22202.

Règles de sécurité en soudage, coupage et procédés connexes, norme CSA W117.2, de l’Association canadienne de normalisation, vente de normes, 178 Rexdale Boulevard, Rexdale (Ontario) Canada M9W 1R3.

Safe Practices For Occupation And Educational Eye And Face Protection, norme ANSI Z87.1, de l’American National Standards Institute, 1430 Broadway, New York, NY 10018.

Cutting and Welding Processes, norme NFPA 51B, de la National Fire Protection Association, Batterymarch Park, Quincy, MA 02269.

1-5. Information sur les champs électromagnétiques

Données sur le soudage électrique et sur les effets, pour l’organisme, des champs magnétiques basse fréquence

Le courant de soudage, pendant son passage dans les câbles de soudage, causera des champs électromagnétiques. Il y a eu et il y a encore un certain souci à propos de tels champs. Cependant, après avoir examiné plus de 500 études qui ont été faites pendant une période de recherche de 17 ans, un comité spécial ruban bleu du National Research Council a conclu: “L’accumulation de preuves, suivant le jugement du comité, n’a pas démontré que l’exposition aux champs magnétiques et champs électriques à haute fréquence représente un risque à la santé humaine”. Toutefois, des études sont toujours en cours et les preuves continuent à être examinées. En attendant que les conclusions finales de la recherche soient établies, il vous serait souhaitable de réduire votre exposition aux champs électromagnétiques pendant le soudage ou le coupage.

Afin de réduire les champs électromagnétiques dans l’environnement de travail, respecter les consignes suivantes :

1 Garder les câbles ensembles en les torsadant ou en les attachant avec du ruban adhésif.
2 Mettre tous les câbles du côté opposé de l’opérateur.
3 Ne pas courber pas et ne pas entourer pas les câbles autour de votre corps.
4 Garder le poste de soudage et les câbles le plus loin possible de vous.
5 Relier la pince de masse le plus près possible de la zone de soudure.

Consignes relatives aux stimulateurs cardiaques :

Les personnes qui portent un stimulateur cardiaque doivent avant tout consulter leur docteur. Si vous êtes déclaré apte par votre docteur, il est alors recommandé de respecter les consignes ci–dessus.

SECTION 2 – DEFINITIONS

2-1. General Precautionary Label

⚠ WARNING

Do Not Remove, Destroy, Or Cover This Label

ARC WELDING can be hazardous.

- Read and follow all labels and the Owner's Manual carefully.
- Only qualified persons are to install, operate, or service this unit according to all applicable codes and safety practices.
- Keep children away.
- Pacemaker wearers keep away.
- Welding wire and drive parts may be at welding voltage.

ELECTRIC SHOCK can kill.

- Always wear dry insulating gloves.
- Insulate yourself from work and ground.
- Do not touch live electrical parts.
- Disconnect input power before servicing.
- Keep all panels and covers securely in place.





WELDING can cause fire or explosion.

- Do not weld near flammable material.
- Watch for fire: keep extinguisher nearby.
- Do not locate unit over combustible surfaces.
- Do not weld on closed containers.



FUMES AND GASES can be hazardous.

- Keep your head out of the fumes.
- Ventilate area, or use breathing device.
- Read Material Safety Data Sheets (MSDSs) and manufacturer's instructions for materials used.



ARC RAYS can burn eyes and skin; NOISE can damage hearing.

- Wear welding helmet with correct filter.
- Wear correct eye, ear, and body protection.

Read American National Standard Z49.1, "Safety In Welding, Cutting, and Allied Processes," From American Welding Society, 550 N.W. LeJeune Rd., Miami, FL 33126; OSHA Safety and Health Standards, 29 CFR 1910, from U.S. Gov. Printing Office, P. O. Box 371954, Pittsburgh, PA 15250-7954.



⚠ AVERTISSEMENT

UN CHOC ELECTRIQUE peut etre mortel.

- Insallation et raccordement de cette machine doivent etre conformes a tous les pertinents.

SOUDAGE A L'ARC peut etre hasardeux.

- Lire le manuel d'instructions avant utilisation.
- Ne pas installer sur une surface combustible.
- Les fils de soudage et pieces conductrices peuvent etre a la tension de soudage.

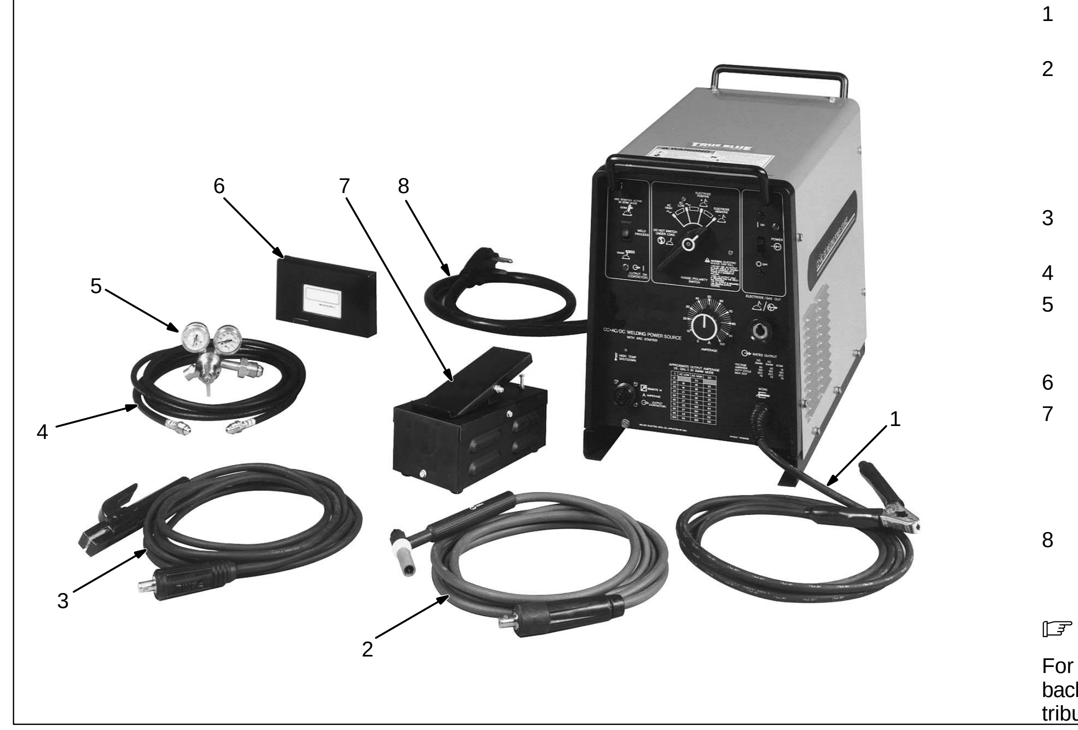
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2-2. Symbols And Definitions

	Tig Welding		Remote Foot/Hand Control		Stick Welding		High Temperature
	Output		Alternating Current		Direct Current		On
	Electrode Positive		Electrode Negative		Do Not Switch Under Load		Voltage Input
A	Amperes		Off		Electrode		Gas Out
	Amperage Control/ Panel		Work		Remote	V	Volts
U_0	Rated No Load Voltage (Average)	U_2	Conventional Load Voltage	X	Duty Cycle	I_{1eff}	Maximum Effective Supply Current
I_{1max}	Rated Maximum Supply Current	I_2	Rated Welding Current	IP	Degree Of Protection		Single-Phase Combined AC/DC Power Source
%	Percent	U_1	Primary Voltage		Line Connection	Hz	Hertz

SECTION 3 – INTRODUCTION

3-1. Included with Your Unit



1 12 ft (3.7 m) Work Cable and Clamp
2 150 Amp TIG Torch with 12-1/2 ft (3.8 m) Cord and Flow-Through Quick-Connect (50 Hz models come with 25 ft (7.6 m) TIG Torch)
3 Electrode Holder and Quick-Connect
4 Gas Hose
5 Gas Regulator (Not included with 50 Hz models)
6 “How-To” Videotape
7 RFC-14 Foot Control with 20 ft (6 m) Cord (60 Hz models only. 50 Hz models come with RCC-14 fingertip control instead.)
8 8 ft (2.4 m) Primary Cord (Plug supplied with 230 Volt model only)

☞ *Some assembly is required.*

For options and accessories see back of book or contact your distributor.

3-2. Specifications

A. 60 Hertz Models

Rated Output at 20% Duty Cycle	Welding Amperage Range AC High AC Low DC	Max. Open-Circuit Voltage	Rated Output	KVA	Dimensions	Net Weight
TIG: 150 A at 15 VDC (GTAW) 150 A at 15 VAC	TIG Welding A Range 50–165 20–50 30–160	78	200 V–60 A (3.6)* 230V–52 A (3.0)* 460 V–33 A (1.5)*	12.0 (0.64)*	H: 18 in (457 mm) W: 13 in (330 mm) D: 25 1/2 in (648 mm)	140 lb (64 kg)
Stick: 130 A at 25 VDC (SMAW) 150 A at 25 VAC	Stick Welding A Range 35–165 20–50 25–130	78				

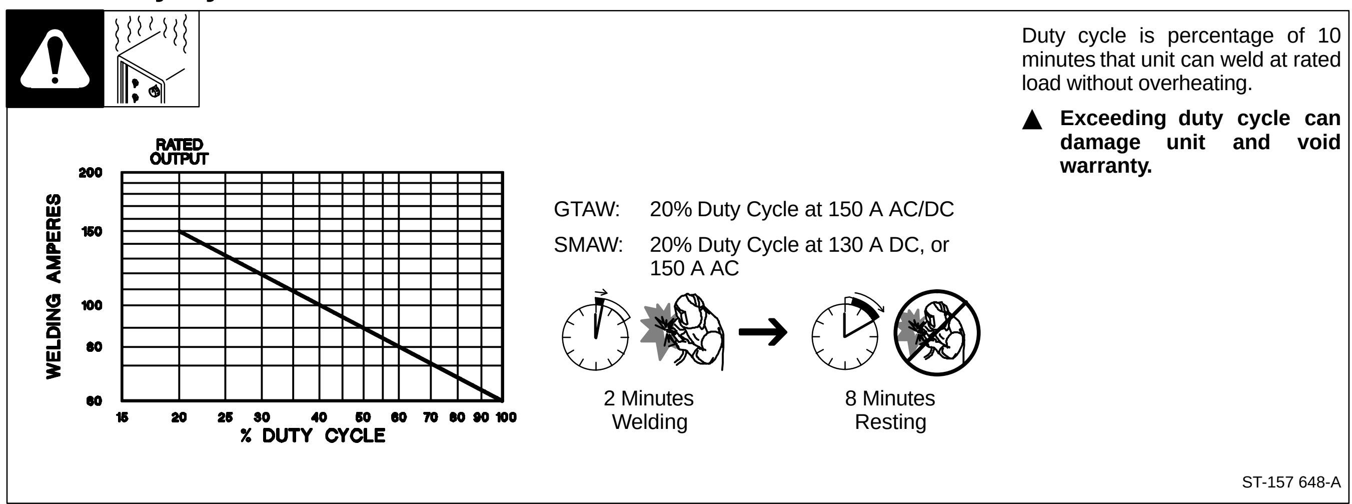
* () While idling.

B. 50 Hertz Models

Rated Output at 20% Duty Cycle	Welding Amperage Range AC High AC Low DC	Max. Open-Circuit Voltage	Rated Output	KVA	Dimensions	Net Weight
TIG: 150 A at 15 VDC (GTAW) 150 A at 15 VAC	TIG Welding A Range 50–165 20–50 30–160	78	380 V–39 A (2.0)* 415V–36 A (1.5)*	14.8 (0.64)*	H: 18 in (457 mm) W: 13 in (330 mm) D: 25 1/2 in (648 mm)	140 lb (64 kg)
Stick: 130 A at 25 VDC (SMAW) 150 A at 25 VAC	Stick Welding A Range 35–165 20–50 25–130	78				

* () While idling.

3-3. Duty Cycle Chart



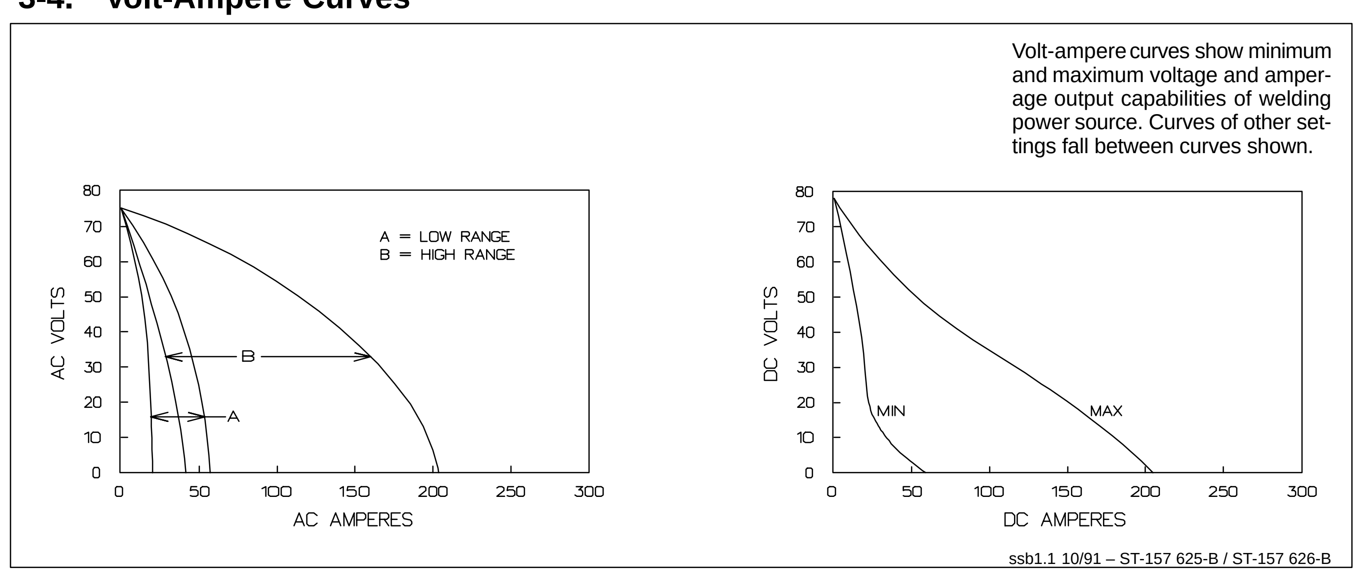
Duty cycle is percentage of 10 minutes that unit can weld at rated load without overheating.

▲ **Exceeding duty cycle can damage unit and void warranty.**

ST-157 648-A

3-4. Volt-Ampere Curves

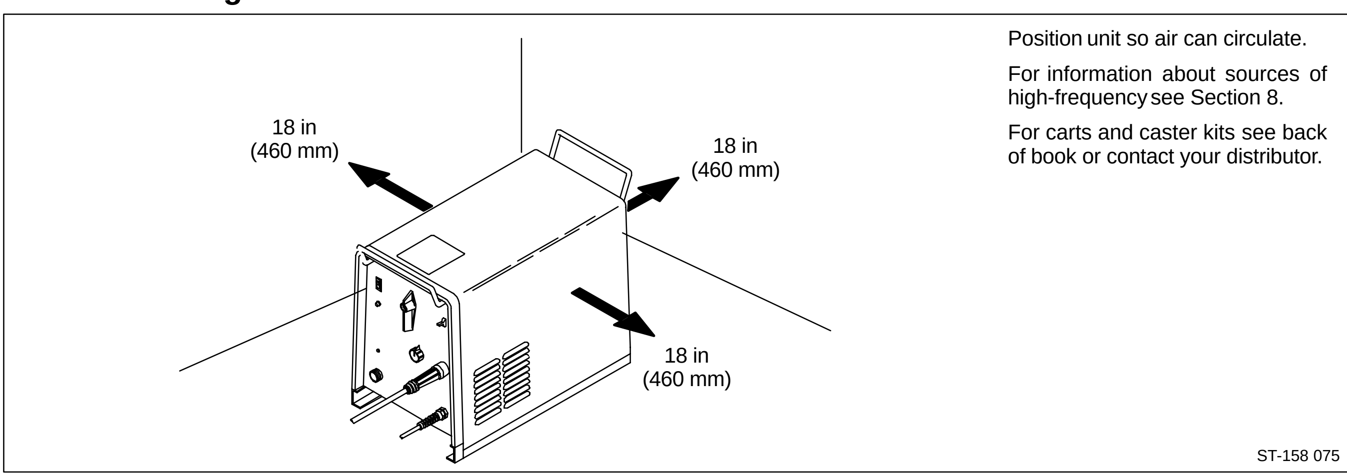
Volt-ampere curves show minimum and maximum voltage and amperage output capabilities of welding power source. Curves of other settings fall between curves shown.



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SECTION 4 – INSTALLATION

4-1. Selecting a Location

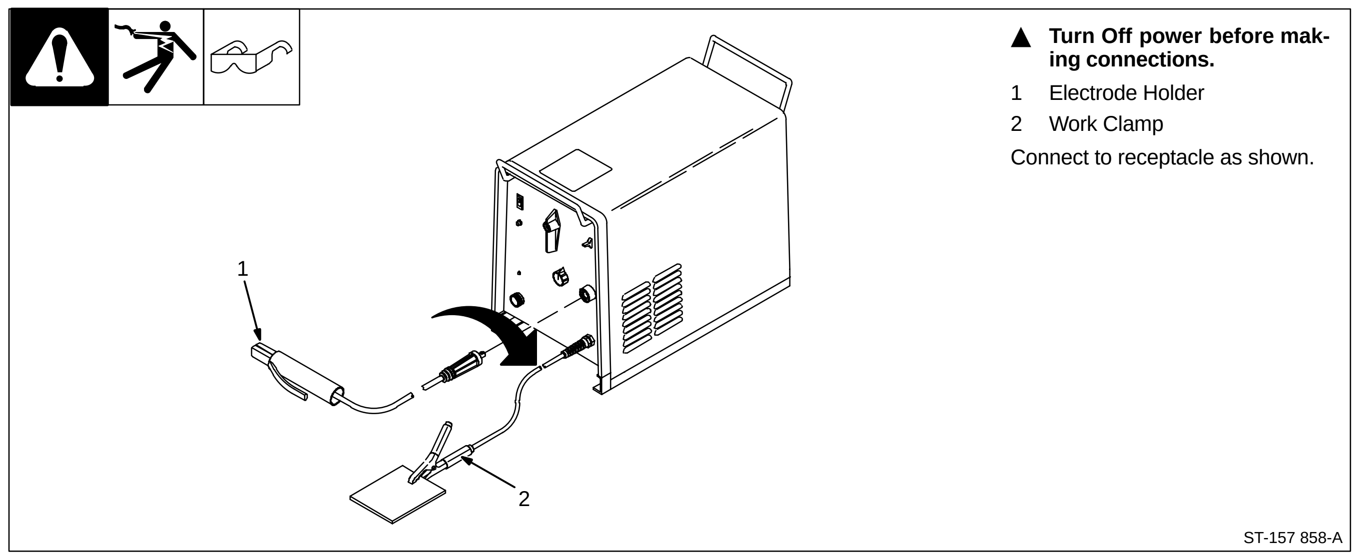


Position unit so air can circulate.

For information about sources of high-frequency see Section 8.

For carts and caster kits see back of book or contact your distributor.

4-2. Typical Stick Connections



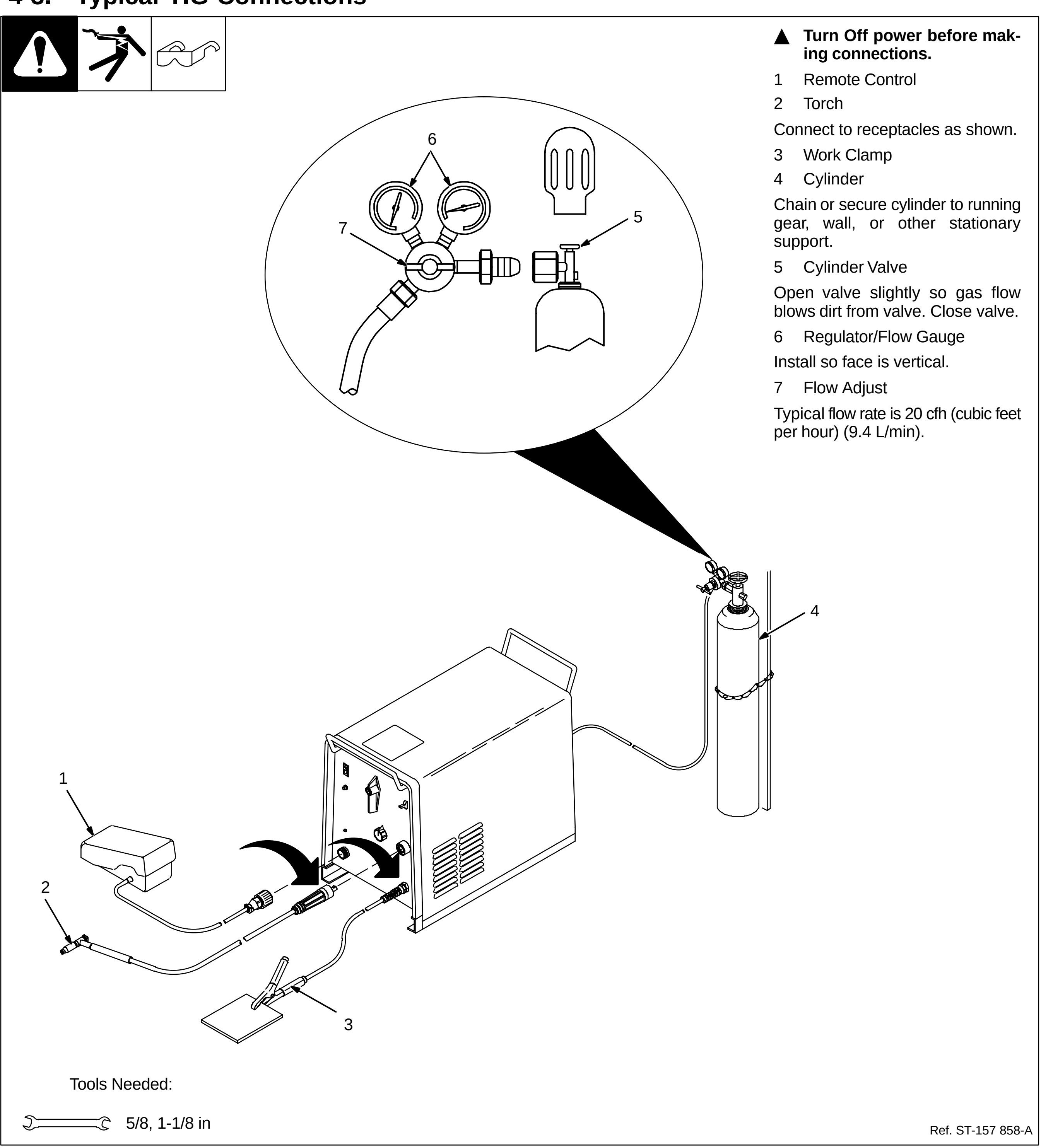
▲ **Turn Off power before making connections.**

1 Electrode Holder

2 Work Clamp

Connect to receptacle as shown.

4-3. Typical TIG Connections



▲ **Turn Off power before making connections.**

1 Remote Control

2 Torch

Connect to receptacles as shown.

3 Work Clamp

4 Cylinder

Chain or secure cylinder to running gear, wall, or other stationary support.

5 Cylinder Valve

Open valve slightly so gas flow blows dirt from valve. Close valve.

6 Regulator/Flow Gauge

Install so face is vertical.

7 Flow Adjust

Typical flow rate is 20 cfh (cubic feet per hour) (9.4 L/min).

4-4. Electrical Service Guide

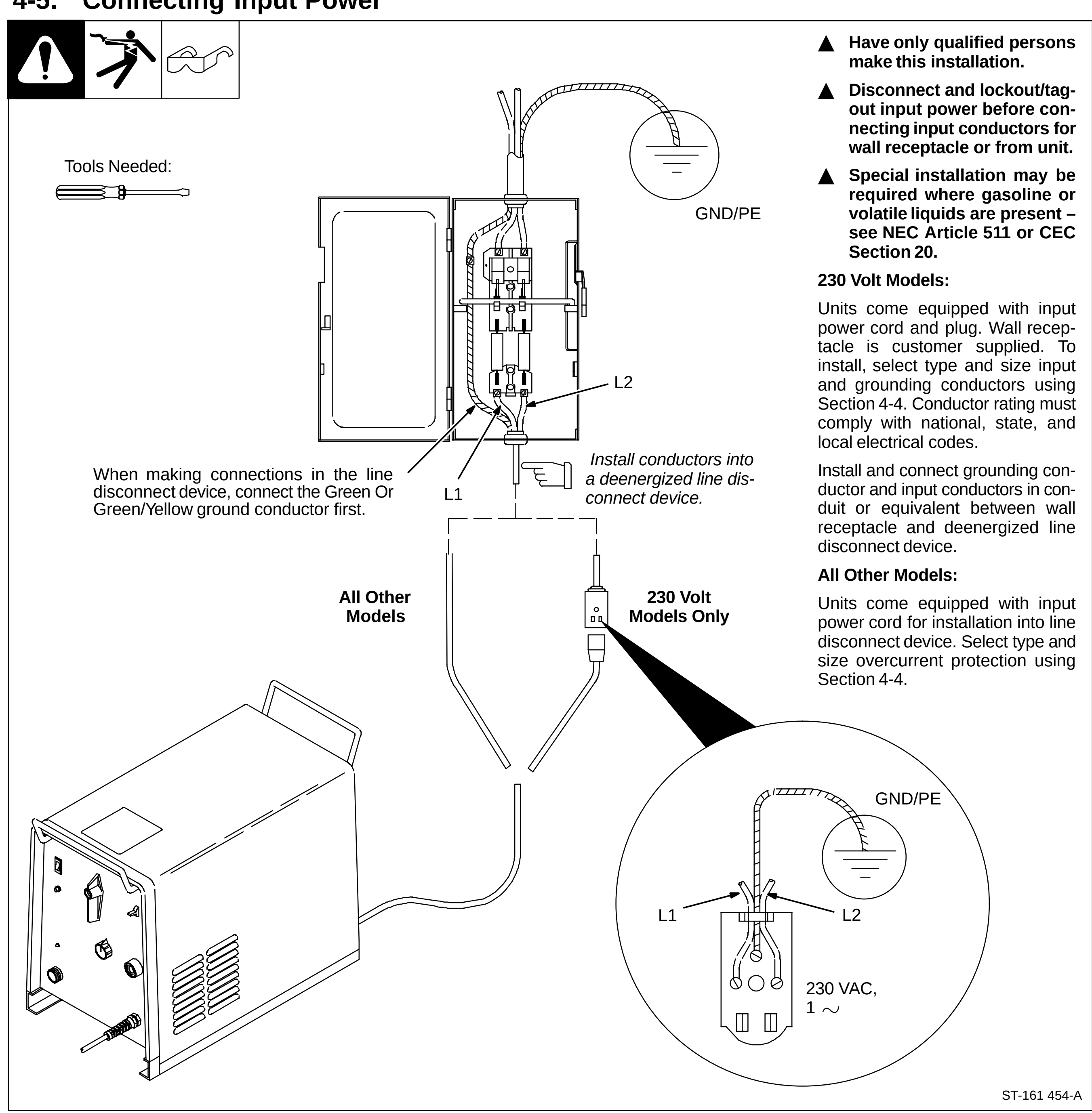
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☞ *For 230 V models with wall receptacle, 100% duty cycle used to calculate data below. 20% duty cycle used for all other models.*

Input Voltage	200	230	380	415	460
Input Amperes at Rated Output	59	52	39	36	33
Standard Fuse or Circuit Breaker Rating (Max. Recommended)	90 Amps	80 Amps	60 Amps	50 Amps	40 Amps
Input Conductor Size (Min.)	10 AWG	6 AWG	12 AWG	12 AWG	14 AWG
Input Conductor Length (Max. Recommended)	42 ft (13 m)	135 ft (41 m)	151 ft (46 m)	181 ft (55 m)	85 ft (26 m)
Grounding Conductor Size (Min.)	10 AWG	8 AWG	12 AWG	12 AWG	14 AWG

Reference: 1996 National Electrical Code (NEC).

4-5. Connecting Input Power



▲ **Have only qualified persons make this installation.**

▲ **Disconnect and lockout/tagout input power before connecting input conductors for wall receptacle or from unit.**

▲ **Special installation may be required where gasoline or volatile liquids are present – see NEC Article 511 or CEC Section 20.**

230 Volt Models:

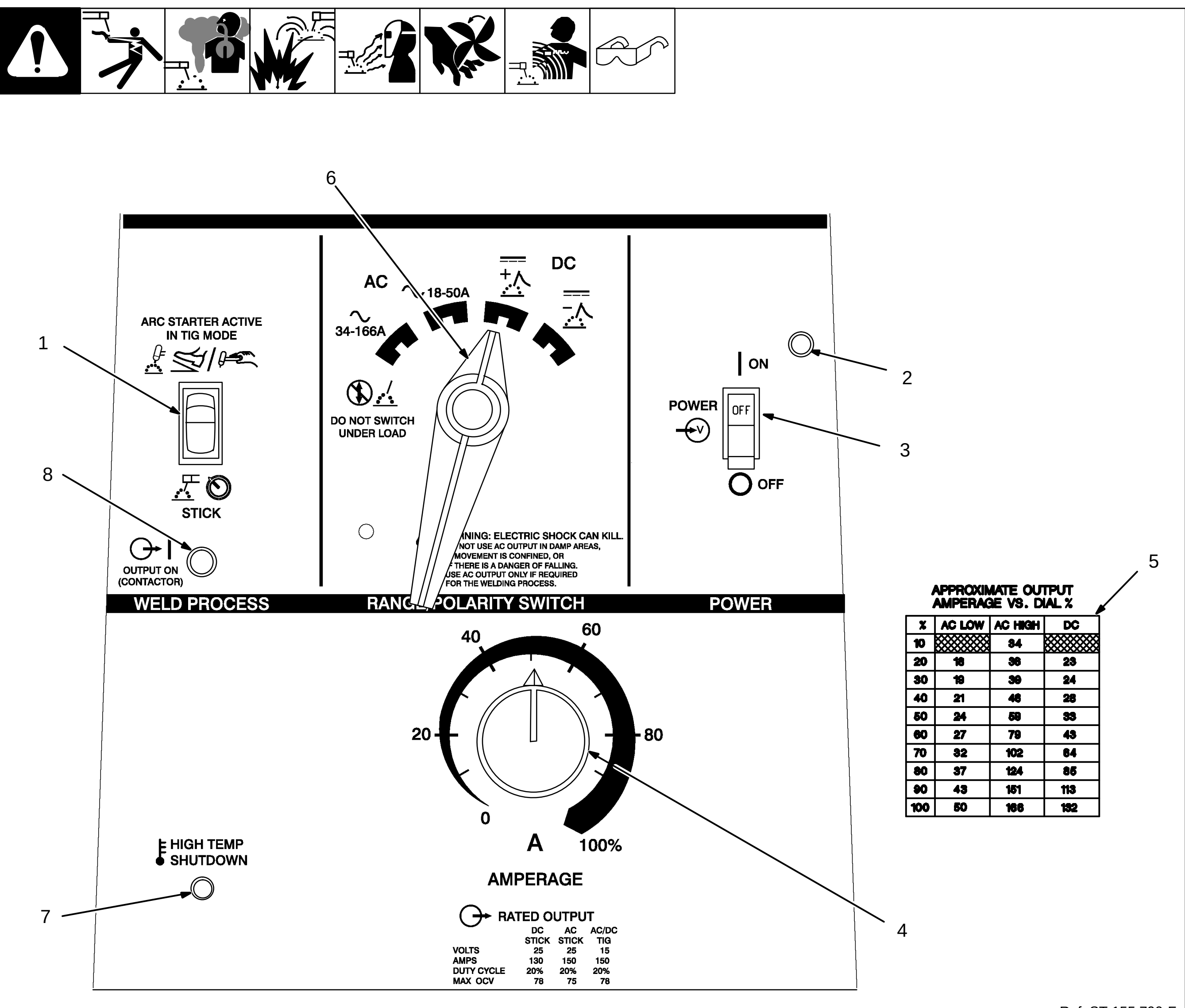
Units come equipped with input power cord and plug. Wall receptacle is customer supplied. To install, select type and size input and grounding conductors using Section 4-4. Conductor rating must comply with national, state, and local electrical codes.

Install and connect grounding conductor and input conductors in conduit or equivalent between wall receptacle and deenergized line disconnect device.

All Other Models:

Units come equipped with input power cord for installation into line disconnect device. Select type and size overcurrent protection using Section 4-4.

5-1. Controls



APPROXIMATE OUTPUT AMPERAGE VS. DIAL %

%	AC LOW	AC HIGH	DC
10		34	
20	16	36	23
30	19	39	24
40	21	46	28
50	24	59	33
60	27	79	43
70	32	102	64
80	37	124	85
90	43	151	113
100	50	166	132

RATED OUTPUT

	DC STICK	AC STICK	AC/DC TIG
VOLTS	25	25	15
AMPS	130	150	150
DUTY CYCLE	20%	20%	20%
MAX OCV	78	75	78

Ref. ST-155 790-F

1 Weld Process Switch

Use switch to select weld process.

In Stick position (down), weld output goes On and Off with Power switch.

In GTAW (TIG) position (up), remote control device turns on and adjusts weld output of unit as limited by Amperage control. Built-in arc starter comes on when needed to start or stabilize welding arc. No adjustments needed for arc starter.

2 Pilot Light

3 Power Switch

Use switch to turn unit, fan, and pilot light On and Off.

4 Amperage Control

For Stick (SMAW), use control to adjust amperage within range selected by the Range/Polarity Switch.

5 Stick (SMAW) Table

Use table to find approximate Stick amperage output at Amperage control setting.

See Section 5-2 for example of front panel amperage control.

For remote amperage control used when TIG (GTAW) welding, front panel Amperage control setting is the maximum amperage percentage available at the remote control device.

See Section 5-3 for example of remote amperage control.

6 Range/Polarity Switch

Use switch to select range and polarity of weld output.

For Direct Current Electrode Negative (DCEN), use Electrode Negative position.

For Direct Current Electrode Positive (DCEP), use Electrode Positive position.

For alternating current (AC), use range needed for welding application – AC Low or AC High position – see Warning.

See Section 5-4 to find suggested type of weld output for application.

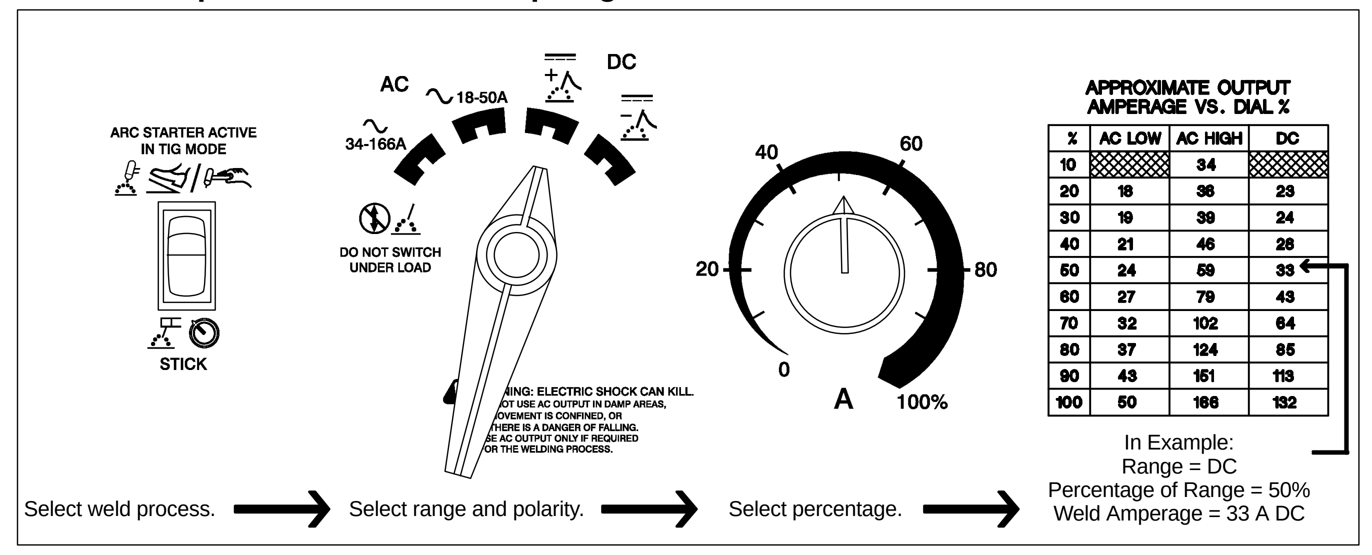
7 High Temperature Shutdown Light

Lights when unit overheats and shuts down (see Section 6-2).

8 Output On (Contactor) Light

Lights when output (contactor) and unit power are on.

5-2. Example of Front Panel Amperage Control



%	AC LOW	AC HIGH	DC
10		34	
20	18	36	23
30	19	39	24
40	21	46	28
50	24	59	33
60	27	79	43
70	32	102	64
80	37	124	85
90	43	151	113
100	50	166	132

In Example:
Range = DC
Percentage of Range = 50%
Weld Amperage = 33 A DC

Select weld process. → Select range and polarity. → Select percentage. →

5-3. Example of Remote Amperage Control

ARC STARTER ACTIVE
IN TIG MODE
STICK

AC
18-50A
34-166A
DC
DO NOT SWITCH
UNDER LOAD

WARNING: ELECTRIC SHOCK CAN KILL.
• DO NOT USE AC OUTPUT IN DAMP AREAS, IF MOVEMENT IS CONFINED, OR IF THERE IS A DANGER OF FALLING.
• USE AC OUTPUT ONLY IF REQUIRED FOR THE WELDING PROCESS.

40
60
20
80
0
A
100%

Select weld process. → Select range and polarity. → Select percentage. →

or

Connect remote control. →

GTAW Welding Amperage Range		
AC Low	AC High	DC
20-50 A	60-165 A	30-165 A

In Example:
Range = DCEN
Percentage of Range = 50%
Remote weld amperage = 30–98 A DC
(50% of 30–165 A DC)

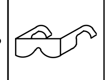
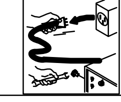
5-4. Process and Material Thickness Guide Label

<table>
<tr><th colspan="12">Guideline For Welding Process And Output For Material</th></tr>
<tr><th rowspan="2">Material And Weld Output</th><th colspan="11">Material Thickness</th></tr>
<tr><th>22 ga
0.033 in
0.8 mm</th><th>20 ga
0.036 in
0.9 mm</th><th>18 ga
0.048 in
1.2 mm</th><th>16 ga
0.06 in
1.5 mm</th><th>14 ga
0.07 in
1.8 mm</th><th>12 ga
0.1 in
2.5 mm</th><th>11 ga
0.125 in
3.2 mm</th><th>10 ga
0.14 in
3.6 mm</th><th>6 ga
0.186 in
4.8 mm</th><th>2 ga
0.25 in
6.3 mm</th><th>–
0.25+ in
6.3+ mm</th></tr>
<tr><td>Steel Or Stainless Steel
(–) DCEN
ELECTRODE NEGATIVE</td><td colspan="2">GTAW
Difficult</td><td colspan="7">GTAW
Recommended</td><td colspan="2">SMAW
With DCEP Output</td></tr>
<tr><td>Aluminum
AC</td><td colspan="4">GTAW
Difficult</td><td colspan="5">GTAW
Recommended</td><td colspan="2">GTAW
Not Recommended</td></tr>
</table>

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SECTION 6 – MAINTENANCE AND TROUBLESHOOTING

6-1. Routine Maintenance

▲ **Disconnect power before maintaining.**

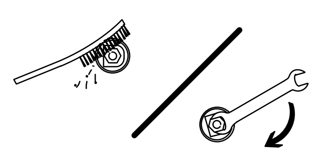
☞ *Maintain more often during severe conditions.*

3 Months

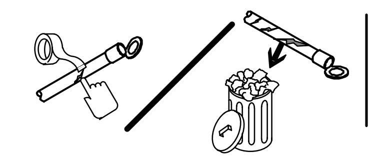
Replace unreadable labels.



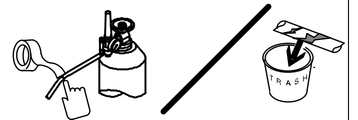
Clean and tighten weld terminals.



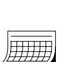
Repair or replace cracked weld cable.



Repair or replace cracked gas hose.

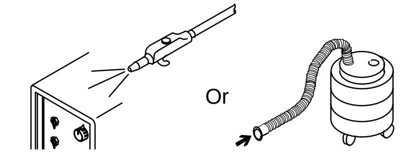


Replace o-ring in Electrode/Gas Output receptacle if cracked.

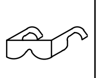
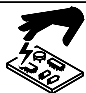
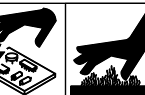


6 Months

Blow out or vacuum inside.

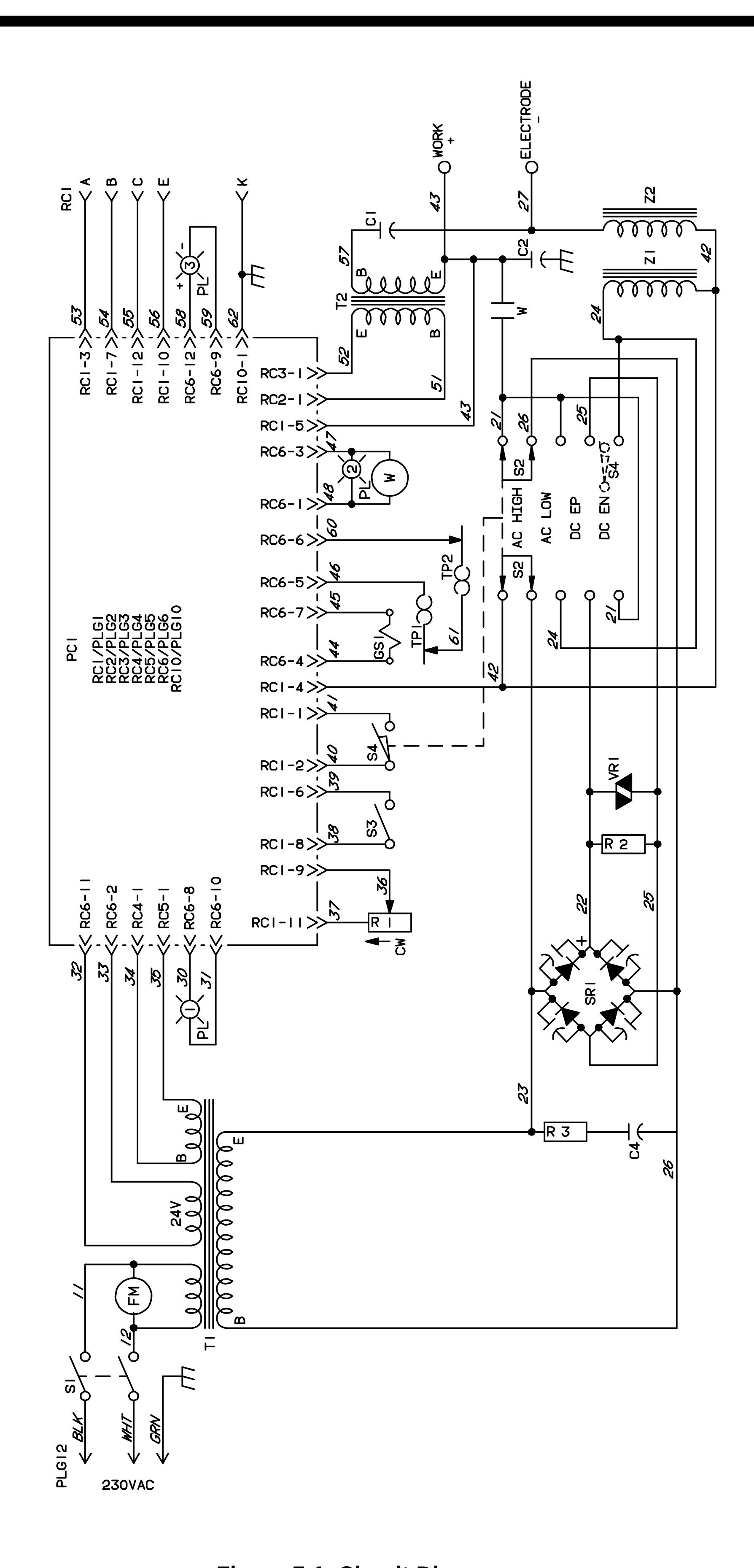


6-2. Troubleshooting

Trouble	Remedy
No weld output; fan does not run.	Place line disconnect switch in On position (see Section 4-5).
	Check and replace line fuse(s), if necessary, or reset circuit breaker (see Section 4-5).
	Check for proper input power connections (see Section 4-5).
No weld output; fan on.	Be sure Range/Polarity switch is not set between positions.
	Tighten remote control connection to Remote 14 receptacle.
	Check remote control (see remote control Owner's Manual).
	Unit overheated. Allow unit to cool (see Section 3-3).
Fan not operating; weld output available.	Check for and remove anything blocking fan movement.
	Have Factory Authorized Service Agent check fan motor.

SECTION 7 – ELECTRICAL DIAGRAMS

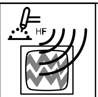
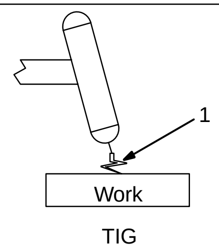


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Figure 7-1. Circuit Diagram

SECTION 8 – HIGH FREQUENCY

8-1. Welding Processes Requiring High Frequency

1 High-Frequency Voltage

Helps arc jump air gap between torch and workpiece and/or stabilize the arc.

high_freq1 11/96 – S-0693

8-2. Incorrect Installation

Weld Zone

11, 12

50 ft (15 m)

Incorrect

S-0694

Sources of Direct High-Frequency Radiation

1 High-Frequency Source (welding power source with built-in HF or separate HF unit)
2 Weld Cables
3 Torch
4 Work Clamp
5 Workpiece
6 Work Table

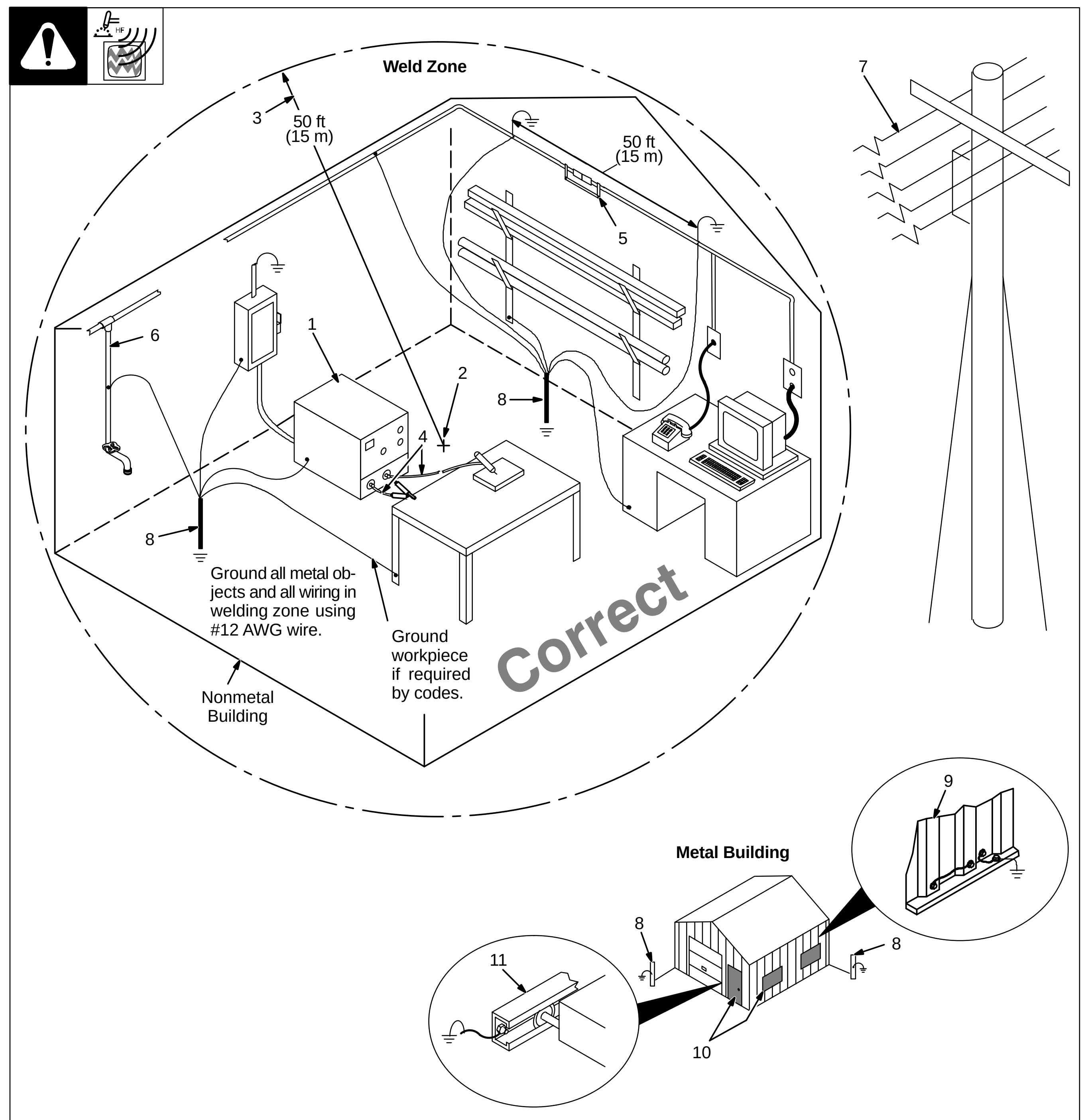
Sources of Conduction of High Frequency

7 Input Power Cable
8 Line Disconnect Device
9 Input Supply Wiring

Sources of Reradiation of High Frequency

10 Ungrounded Metal Objects
11 Lighting
12 Wiring
13 Water Pipes and Fixtures
14 External Phone and Power Lines

8-3. Correct Installation



1 High-Frequency Source (welding power source with built-in HF or separate HF unit)

Ground metal machine case, work output terminal, line disconnect device, input supply, and worktable.

2 Center Point of Welding Zone

Midpoint between high-frequency source and welding torch.

3 Welding Zone

A circle 50 ft (15 m) from center point in all directions.

4 Weld Output Cables

Keep cables short and close together.

5 Conduit Joint Bonding and Grounding

Electrically join (bond) all conduit sections using copper straps or braided wire. Ground conduit every 50 ft (15 m).

6 Water Pipes and Fixtures

Ground water pipes every 50 ft (15 m).

7 External Power or Telephone Lines

Locate high-frequency source at least 50 ft (15 m) away from power and phone lines.

8 Grounding Rod

Consult the National Electrical Code for specifications.

Metal Building Requirements

9 Metal Building Panel Bonding Methods

Bolt or weld building panels together, install copper straps or braided wire across seams, and ground frame.

10 Windows and Doorways

Cover all windows and doorways with grounded copper screen of not more than 1/4 in (6.4 mm) mesh.

11 Overhead Door Track

Ground the track.

SECTION 9 – PARTS LIST

☞ *Hardware is common and not available unless listed.*

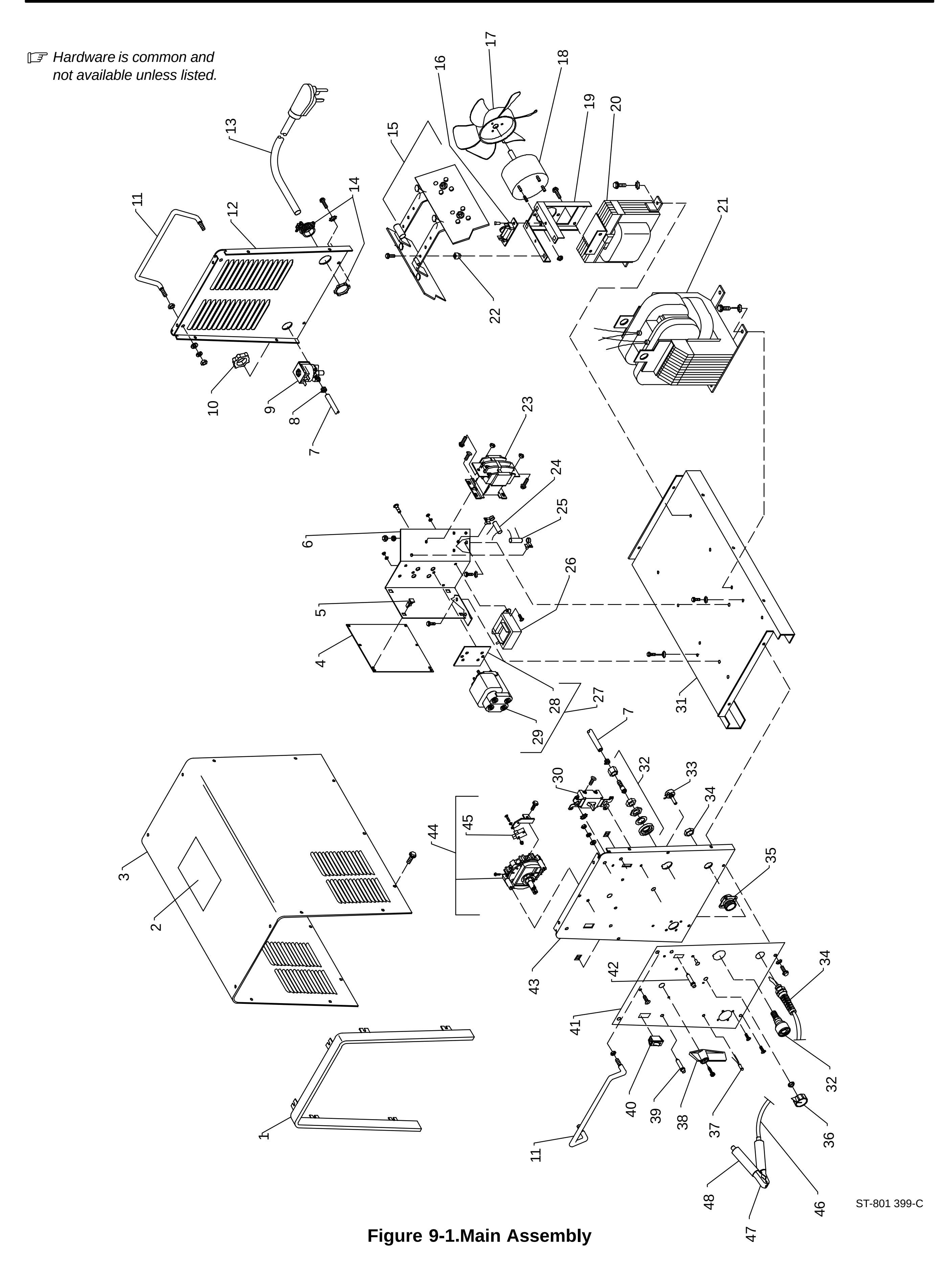


Figure 9-1.Main Assembly

Item No.	Dia. Mkgs.	Part No.	Description	Quantity

Figure 9-1. Main Assembly

Item No.	Dia. Mkgs.	Part No.	Description	Quantity
1		154 335	BEZEL, front	1
2		203 990	LABEL, warning general precautionary	1
3		+165 986	WRAPPER,	1
4	PC1	183 876	CIRCUIT CARD, arc start/control (200, 230, 460V models) (consisting of)	1
4	PC1	186 172	CIRCUIT CARD, arc start/control (380, 415V models) (consisting of)	1
	F1	*012 658	FUSE, mintr gl slo-blo 2A	1
	PLG1,6	130 203	CONNECTOR & SOCKETS	2
5		134 201	STAND-OFF SUPPORT, PC card .312/.375	4
6		155 404	BRACKET, mtg components	1
7		603 106	HOSE, nprn brd No. 1 (order by ft)	3ft
8		089 120	CLAMP, hose .430-.515 clp dia	2
9	GS1	125 785	VALVE, 24VAC 2 way custom port 1/8 orf	1
10		605 227	NUT, nylon hex jam .750NPST	1
11		147 571	HANDLE	2
12		155 399	PANEL, rear	1
13		071 906	CORD SET, 8-10ga 3/c (200V model)	1
13	PLG12	047 721	CORD SET, 250V 6-50P 8-10ga 3/c (230V model)	1
13		605 077	CABLE, port No. 10 3/c (380, 415, 460V Model) (order by ft)	8ft
14		604 102	CONNECTOR, clamp cable 1.000	1
15	SR1	193 317	RECTIFIER	1
16	VR1,R2	044 482	SUPPRESSOR	1
17		150 783	BLADE, fan 9 in .312 hub	1
18	FM	188 706	MOTOR, fan 230V 1550RPM .312dia shaft	1
19		203 598	BRACKET, mtg fan & rectifier	1
20	Z1	193 871	STABILIZER	1
21	T1	193 869	TRANSFORMER, pwr main 200V (consisting of)	1
21	T1	193 873	TRANSFORMER, pwr main 230V (consisting of)	1
21	T1	193 874	TRANSFORMER, pwr main 460V (consisting of)	1
21	T1	193 875	TRANSFORMER, pwr main 380V (consisting of)	1
21	T1	193 877	TRANSFORMER, pwr main 415V (consisting of)	1
	TP1,2	176 170	THERMOSTAT, NC	2
22		083 147	GROMMET, screw No. 8/10 panel hole .312sq .500 high	4
23	W	188 009	CONTACTOR	1
24	C2	155 501	CAPACITOR	1
25	C1	155 290	CAPACITOR	1
26	T2	188 061	TRANSFORMER, impulse HV	1
27	Z2	155 499	TRANSFORMER, blocking (consisting of)	1
28		159 102	PLATE, mtg block transformer	1
29		155 288	COIL, blocking	1
30	S1	124 511	SWITCH, tgl DPST 40A 600VAC	1
31		165 987	BASE	1
32	Elec	186 092	RECEPTACLE KIT, dinse	1
33	R1	035 897	POTENTIOMETER, C sltd 1T 2W 1K ohm	1
34		134 900	STRAIN RELIEF, cable flex .270-.480 cable	1
35	RC1	143 976	CONNECTOR w/SOCKETS	1
36		097 924	KNOB, pointer	1
37	PL3	155 500	LIGHT, indicator	1
38		148 956	HANDLE, switch	1
39	PL2	157 957	LIGHT, ind blu lens 28V snap mtg	1
40	S3	155 013	SWITCH, rocker SPST 10A 250VAC	1
41			NAMEPLATE, (order by model and serial number)	1

Item No.	Dia. Mkgs.	Part No.	Description	Quantity
			Figure Figure 9-1. Main Assembly (Continued)	
42	PL1	157 958	LIGHT, ind wht lens 28V	1
43		155 422	PANEL, front	1
44	S2	154 896	SWITCH, polarity (consisting of)	1
45	S4	089 645	SWITCH, lim 11A 125V roller lever actr	1
46		177 359	CABLE, work assembly (consisting of)	1
47		010 368	CLAMP, work 200A	1
48		026 843	INSULATOR, vinyl black	2
		128 188	HOSE, gas	1
		193 094	REGULATOR/FLOWMETER w/ gas hose	1
		176 840	ELECTRODE HOLDER/CABLE, (consisting of)	1
		134 460	CONNECTOR, twlk insul male	1

+When ordering a component originally displaying a precautionary label, the label should also be ordered.
*Recommended Spare Parts.
To maintain the factory original performance of your equipment, use only Manufacturer's Suggested Replacement Parts. Model and serial number required when ordering parts from your local distributor.

HOBART WARRANTY

Effective January 1, 2001
(Equipment with a serial number preface of “LB” or newer)

This limited warranty supersedes all previous Hobart warranties and is exclusive with no other guarantees or warranties expressed or implied.

Warranty Questions?

Call
1-877-HOBART1
for your local
Hobart distributor.

Service
You always get the fast, reliable response you need. Most replacement parts can be in your hands in 24 hours.

Support
Need fast answers to the tough welding questions? Contact your distributor or call 1-800-332-3281. The expertise of the distributor and Hobart is there to help you, every step of the way.



LIMITED WARRANTY – Subject to the terms and conditions below, Hobart Welding Products., Troy, Ohio, warrants to its original retail purchaser that new Hobart equipment sold after the effective date of this limited warranty is free of defects in material and workmanship at the time it is shipped by Hobart. THIS WARRANTY IS EXPRESSLY IN LIEU OF ALL OTHER WARRANTIES, EXPRESS OR IMPLIED, INCLUDING THE WARRANTIES OF MERCHANTABILITY AND FITNESS.

Within the warranty periods listed below, Hobart will repair or replace any warranted parts or components that fail due to such defects in material or workmanship. Hobart must be notified in writing within thirty (30) days of such defect or failure, at which time Hobart will provide instructions on the warranty claim procedures to be followed.

Hobart shall honor warranty claims on warranted equipment listed below in the event of such a failure within the warranty time periods. All warranty time periods start on the date that the equipment was delivered to the original retail purchaser, or one year after the equipment is sent to a North American distributor or eighteen months after the equipment is sent to an International distributor.

1. 5 Years Parts – 3 Years Labor
   * Original main power rectifiers
   * Inverters (input and output rectifiers only)
2. 3 Years — Parts and Labor
   * Transformer/Rectifier Power Sources
   * Plasma Arc Cutting Power Sources
   * Semi-Automatic and Automatic Wire Feeders
   * Inverter Power Supplies
   * Intellitig
   * Engine Driven Welding Generators
     (NOTE: Engines are warranted separately by the engine manufacturer.)
3. 1 Year — Parts and Labor
   * DS-2 Wire Feeder
   * Motor Driven Guns (w/exception of Spoolmate Spoolguns)
   * Process Controllers
   * Positioners and Controllers
   * Automatic Motion Devices
   * RFCS Foot Controls
   * Induction Heating Power Sources
   * Water Coolant Systems
   * HF Units
   * Grids
   * Maxstar 140
   * Spot Welders
   * Load Banks
   * Hobart Cyclomatic Equipment
   * Running Gear/Trailers
   * Plasma Cutting Torches (except APT & SAF Models)
   * Field Options
     (NOTE: Field options are covered under True Blue® for the remaining warranty period of the product they are installed in, or for a minimum of one year — whichever is greater.)
4. 6 Months — Batteries
5. 90 Days — Parts
   * MIG Guns/TIG Torches
   * Induction Heating Coils and Blankets
   * APT, ZIPCUT & PLAZCUT Model Plasma Cutting Torches
   * Remote Controls
   * Accessory Kits
   * Replacement Parts (No labor)
   * Spoolmate Spoolguns
   * Canvas Covers

HOBART’s Limited Warranty shall not apply to:

1. **Consumable components; such as contact tips, cutting nozzles, contactors, brushes, slip rings, relays or parts that fail due to normal wear.**
2. Items furnished by Hobart, but manufactured by others, such as engines or trade accessories. These items are covered by the manufacturer’s warranty, if any.
3. Equipment that has been modified by any party other than Hobart, or equipment that has been improperly installed, improperly operated or misused based upon industry standards, or equipment which has not had reasonable and necessary maintenance, or equipment which has been used for operation outside of the specifications for the equipment.

HOBART PRODUCTS ARE INTENDED FOR PURCHASE AND USE BY COMMERCIAL/INDUSTRIAL USERS AND PERSONS TRAINED AND EXPERIENCED IN THE USE AND MAINTENANCE OF WELDING EQUIPMENT.

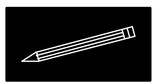
In the event of a warranty claim covered by this warranty, the exclusive remedies shall be, at Hobart’s option: (1) repair; or (2) replacement; or, where authorized in writing by Hobart in appropriate cases, (3) the reasonable cost of repair or replacement at an authorized Hobart service station; or (4) payment of or credit for the purchase price (less reasonable depreciation based upon actual use) upon return of the goods at customer’s risk and expense. Hobart’s option of repair or replacement will be F.O.B., Factory at Appleton, Wisconsin, or F.O.B. at a Hobart authorized service facility as determined by Hobart. Therefore no compensation or reimbursement for transportation costs of any kind will be allowed.

TO THE EXTENT PERMITTED BY LAW, THE REMEDIES PROVIDED HEREIN ARE THE SOLE AND EXCLUSIVE REMEDIES. IN NO EVENT SHALL HOBART BE LIABLE FOR DIRECT, INDIRECT, SPECIAL, INCIDENTAL OR CONSEQUENTIAL DAMAGES (INCLUDING LOSS OF PROFIT), WHETHER BASED ON CONTRACT, TORT OR ANY OTHER LEGAL THEORY.

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Some states in the U.S.A. do not allow limitations of how long an implied warranty lasts, or the exclusion of incidental, indirect, special or consequential damages, so the above limitation or exclusion may not apply to you. This warranty provides specific legal rights, and other rights may be available, but may vary from state to state.

In Canada, legislation in some provinces provides for certain additional warranties or remedies other than as stated herein, and to the extent that they may not be waived, the limitations and exclusions set out above may not apply. This Limited Warranty provides specific legal rights, and other rights may be available, but may vary from province to province.



Owner's Record

Please complete and retain with your personal records.

Model Name	Serial/Style Number
Purchase Date	(Date which equipment was delivered to original customer.)
Distributor	
Address	
City	
State	Zip



Resources Available

Always provide Model Name and Serial/Style Number.

To locate a Distributor, retail or service location:

Call 1-877-Hobart1 or visit our website at www.HobartWelders.com

For technical assistance:

Call 1-800-332-3281

Contact your Distributor for:

Welding Supplies and Consumables

Options and Accessories

Personal Safety Equipment

Service and Repair

Replacement Parts

Training (Schools, Videos, Books)

Technical Manuals (Servicing Information and Parts)

Circuit Diagrams

Welding Process Handbooks

Contact the Delivering Carrier for:

For assistance in filing or settling claims, contact your distributor and/or equipment manufacturer's Transportation Department.

File a claim for loss or damage during shipment.

Hobart Welding Products
An Illinois Tool Works Company
600 West Main Street
Troy, OH 45373 USA

For Technical Assistance:
Call1-800-332-3281
For Literature Or Nearest Dealer:
Call 1-877-Hobart1

